

Work Order ID 89366

August-24-12 1:34:21 PM

Item ID: D3121-241
Revision ID:
Item Name: Bearing Assembly
Start Date: 8/21/12 Sta
Required Date: 9/07/12 Rec
Reference:

Approvals: Process Plan:
QC:

Sequence ID/
Work Center ID
130
130
Small Fab
Small Fab

140
140
QC
Quality Control

150
150
Packaging
Packaging

Work Order ID 89366

August-24-12 1:34:21 PM

Item ID: D3121-241
Revision ID:
Item Name: Bearing Assembly
Start Date: 8/21/12 Start Qty: 60.00
Required Date: 9/07/12 Req'd Qty: 60.00
Reference:

Approvals: Process Plan: MLJ Date: 12/08/12
QC: Date: Tooling: SPC (Y/N):

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3121	Rev E								
100	Hardinge CNC LATHE SMALL	0.00							
100	Hardinge	0.00							
Hardinge CNC Lathe Small	Memo								
	1-Turn D3121-25 Cap as per Folio FA3872-Debur								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
120	QC	0.00							
Quality Control	Memo								

89366

Page 1

N900040100 Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

12/09/26 80 0

12/09/26 80 0

12/09/27 80 0

NCR: Yes / No

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION				AGAINST DEPARTMENT/PROCESS							
	Rework <input type="checkbox"/>				Skid-tube <input type="checkbox"/>		Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>	
	Scrap <input type="checkbox"/>				Machining <input type="checkbox"/>		Small Fab <input type="checkbox"/>		Prod. Eng. Coord. <input type="checkbox"/>		Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>				Thermoforming <input type="checkbox"/>		Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>	
	Work Order Update <input type="checkbox"/>				Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>			

Root Cause	Date	Step
Doc/Data		
Equip/Tooling		
Operator		
Material		
Setup		
Other		
Process		
Supplier		
Training		
Unapproved		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear

☐ Bending

☐ Centre Not Concentric

☐ Cracks

☐ Crushed/Crimped

☐ Cuffs

☐ Heat Treat

☐ Inspection Strip in

☐ Ripples in Bend

☐ Torque Waves in E

☐ Turning Sequence

☐ Wave/Twist in Tu

<p>Landing Gear</p> <p><input type="checkbox"/> Bending</p> <p><input type="checkbox"/> Centre Not Concentric to O/S</p> <p><input type="checkbox"/> Cracks</p> <p><input type="checkbox"/> Crushed/Crimped</p> <p><input type="checkbox"/> Cuffs</p> <p><input type="checkbox"/> Heat Treat</p> <p><input type="checkbox"/> Inspection Strip in Tube</p> <p><input type="checkbox"/> Ripples in Bend</p> <p><input type="checkbox"/> Torque Waves in Extrusion</p> <p><input type="checkbox"/> Turning Sequence</p> <p><input type="checkbox"/> Wave/Twist in Tube</p>	<p>General</p> <p><input type="checkbox"/> Bend</p> <p><input type="checkbox"/> BOM/Route</p> <p><input type="checkbox"/> Broken/Damaged</p> <p><input type="checkbox"/> Burrs</p> <p><input type="checkbox"/> Contamination</p> <p><input type="checkbox"/> Countersink</p> <p><input type="checkbox"/> Cut Too Short</p> <p><input type="checkbox"/> Drill Holes</p> <p><input type="checkbox"/> Drawing</p> <p><input type="checkbox"/> Finish</p> <p><input type="checkbox"/> Folio</p>	<p><input type="checkbox"/> Grain</p> <p><input type="checkbox"/> Hardware</p> <p><input type="checkbox"/> Inspection Incomplete</p> <p><input type="checkbox"/> Instructions Incomplete/Unclear</p> <p><input type="checkbox"/> Maintenance</p> <p><input type="checkbox"/> Mislabeled</p> <p><input type="checkbox"/> Misread</p> <p><input type="checkbox"/> Offset</p> <p><input type="checkbox"/> Out of Calibration</p> <p><input type="checkbox"/> Out of Sequence</p> <p><input type="checkbox"/> Outside Dimensions</p>	<p><input type="checkbox"/> Ovalized</p> <p><input type="checkbox"/> Over/Under tolerance</p> <p><input type="checkbox"/> Part Incorrect</p> <p><input type="checkbox"/> Part Lost/Missing</p> <p><input type="checkbox"/> Part Moved</p> <p><input type="checkbox"/> Positioned Wrong</p> <p><input type="checkbox"/> Power Loss/Surge</p>	<p><input type="checkbox"/> Pressure/Forced</p> <p><input type="checkbox"/> Temperature/Cure</p> <p><input type="checkbox"/> Weld</p> <p><input type="checkbox"/> Wrong Stock Pulled</p> <p><input type="checkbox"/> Other</p>
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H:/FORMS/Quality Assurance/approved QA/NCRWO Rev G

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev G

Picklist Print

August-24-12 1:34:20 PM

Page 1

Work Order ID: 89366
 Parent Item: D3121-241
 Parent Item Name: Bearing Assembly

Start Date: 8/21/12 Required Date: 9/07/12
 Start Qty: 60.00 Required Qty: 60.00

Comments: IPP Rev:A04.02.18New issueKJ/DS
 IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.000 Delrin Round Bar 1"		Purchased	No			100	f	65.9359	0.052	3.12		8/12/09/26	

Location	Loc Qty	Loc Code
MAT055	65.9359	
117985	0.407	
118392	6.2762	
119306	11.2527	
122582	48	

D3121-23
 Bearing

Manufactured No

130 Each 85.0000 1 60

Location	Loc Qty	Loc Code
ST235	85	
66734	10	
75084	2	
85569	73	

B90103 (800)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

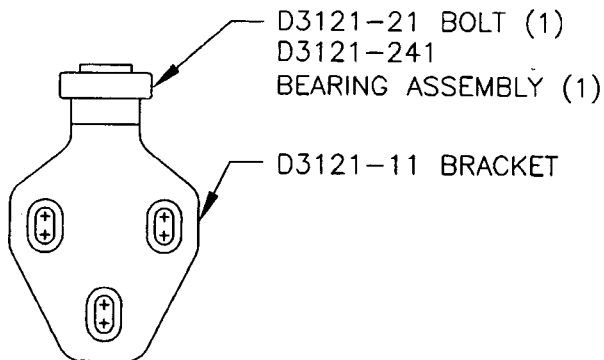
DQA: _____ Date: _____

QA Closed: _____ Date: _____

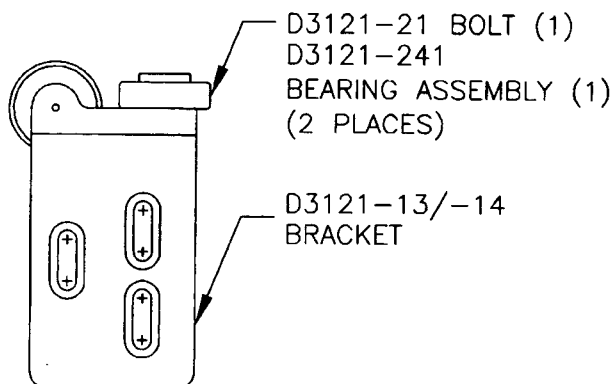
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

DART

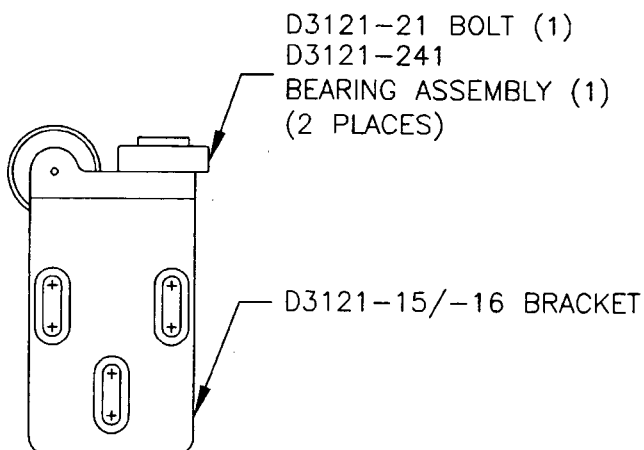
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED
07.11.07

D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

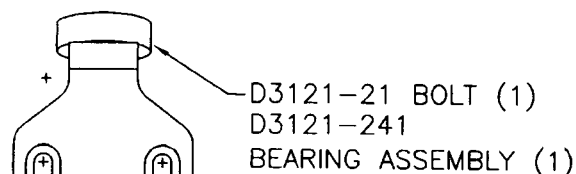
12/08/29
NO. 89366145
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

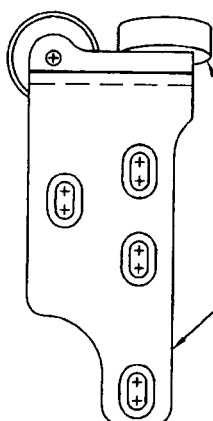


D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

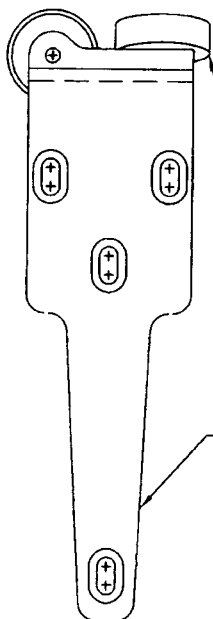
RELEASED
07.11.07



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

093060

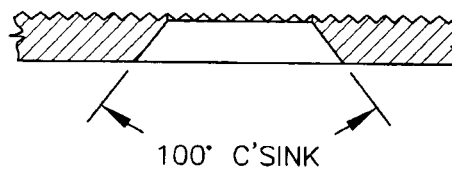
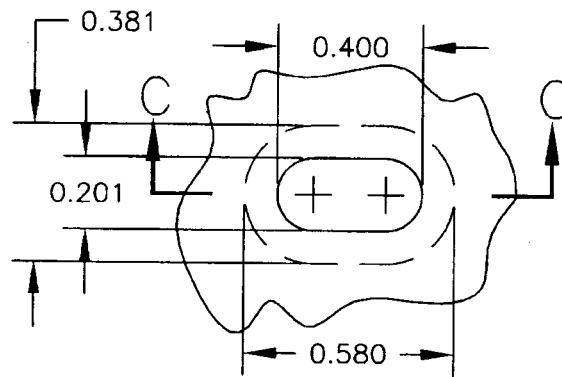
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

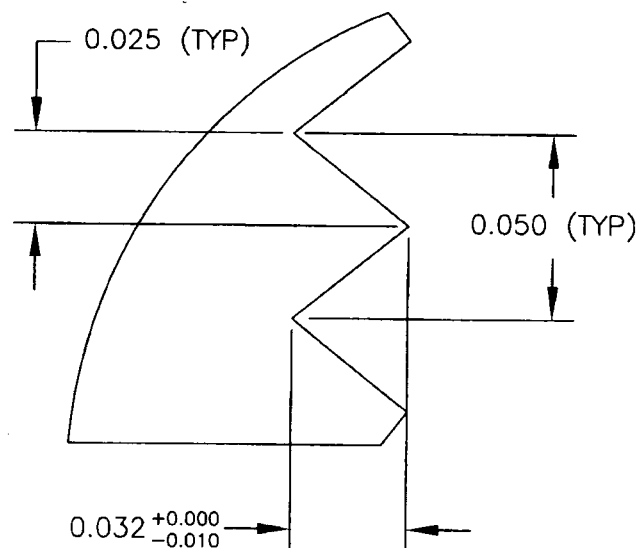
**DETAIL A:
SLOT DETAIL**
SCALE 2:1
VIEW ROTATED



**SECTION
C-C**

RELEASED
07.11.07

**DETAIL B:
RIDGE DETAIL**
PARTIAL SECTION
SCALE 1:20



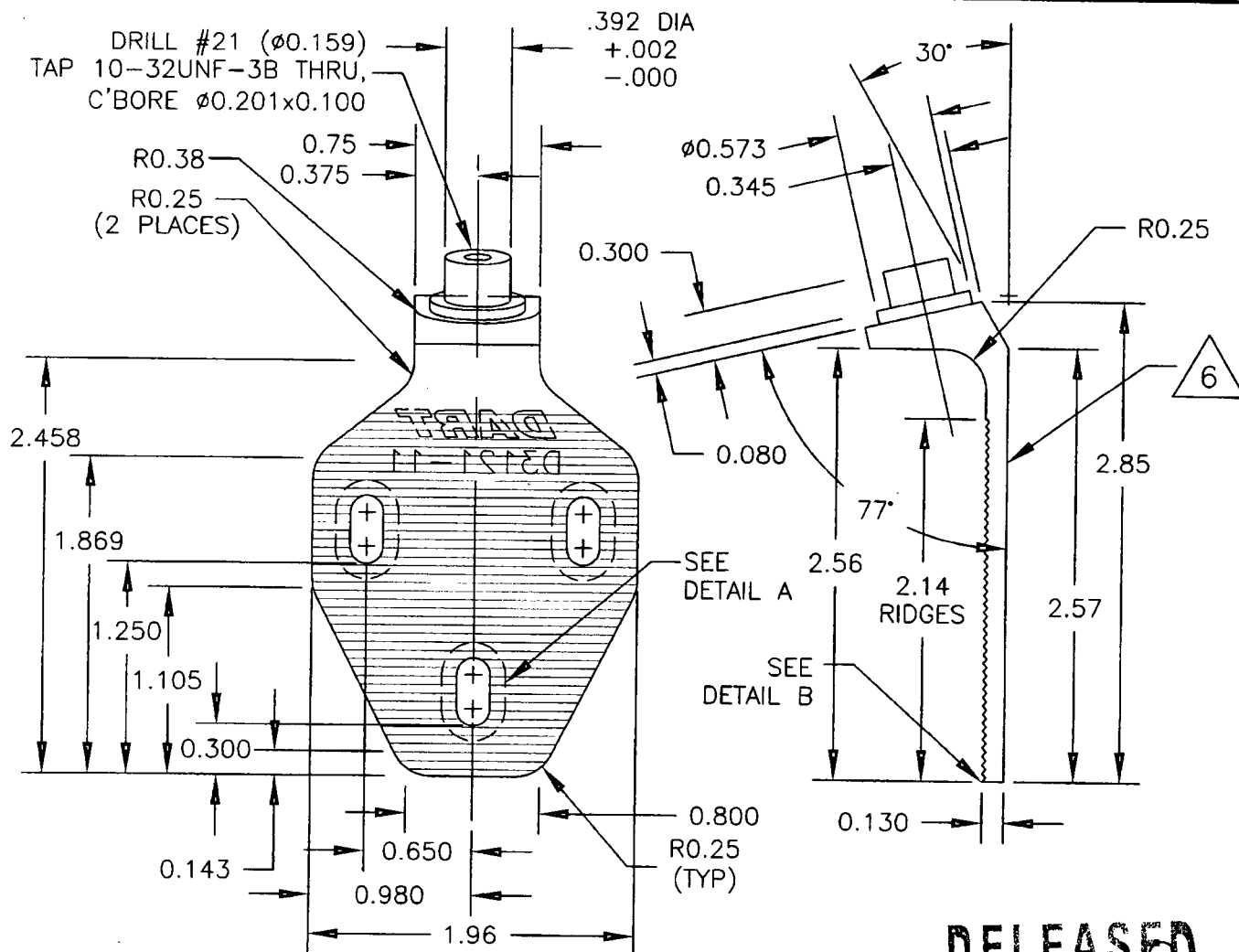
09364

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 4 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



RELEASED
07.11.07

D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

09366

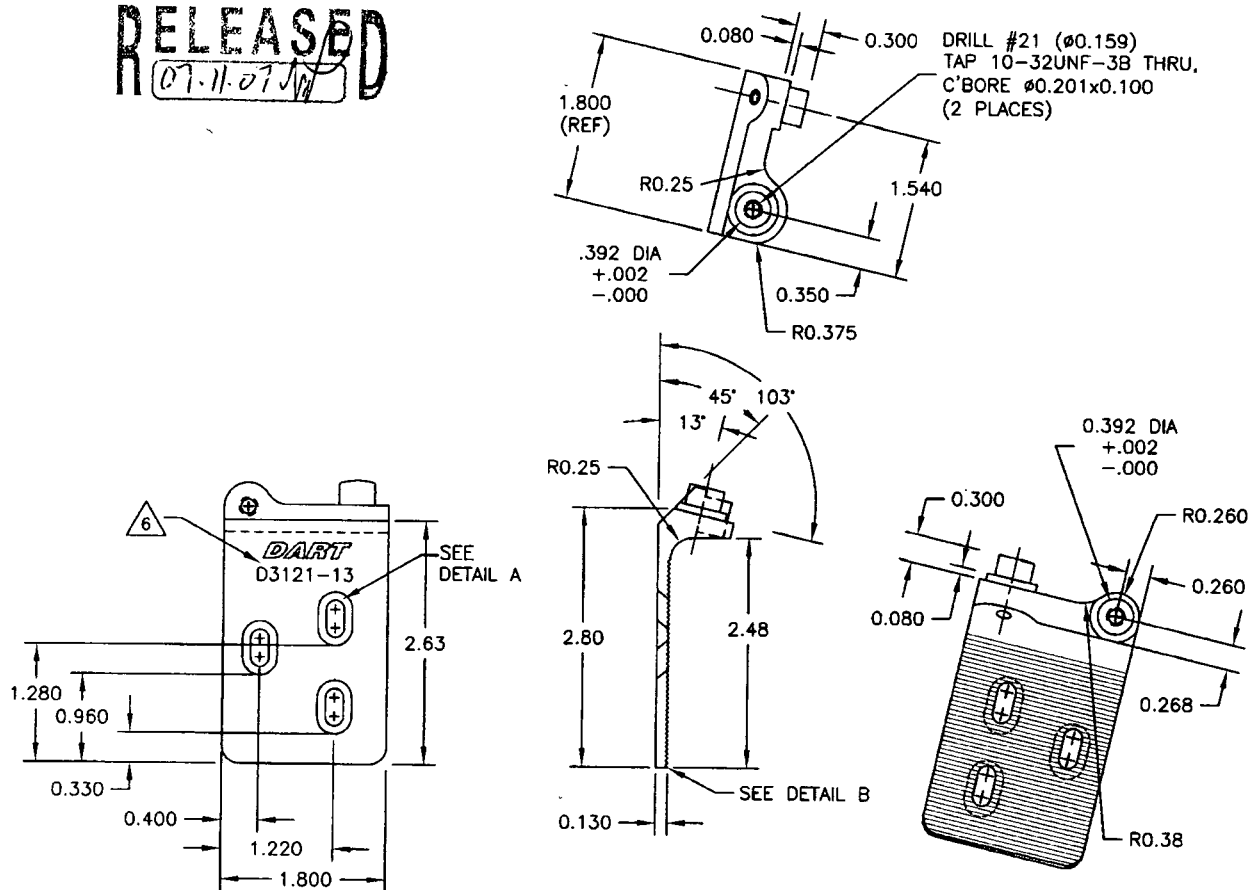
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



D3121-13 BRACKET (SHOWN)

D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

89366

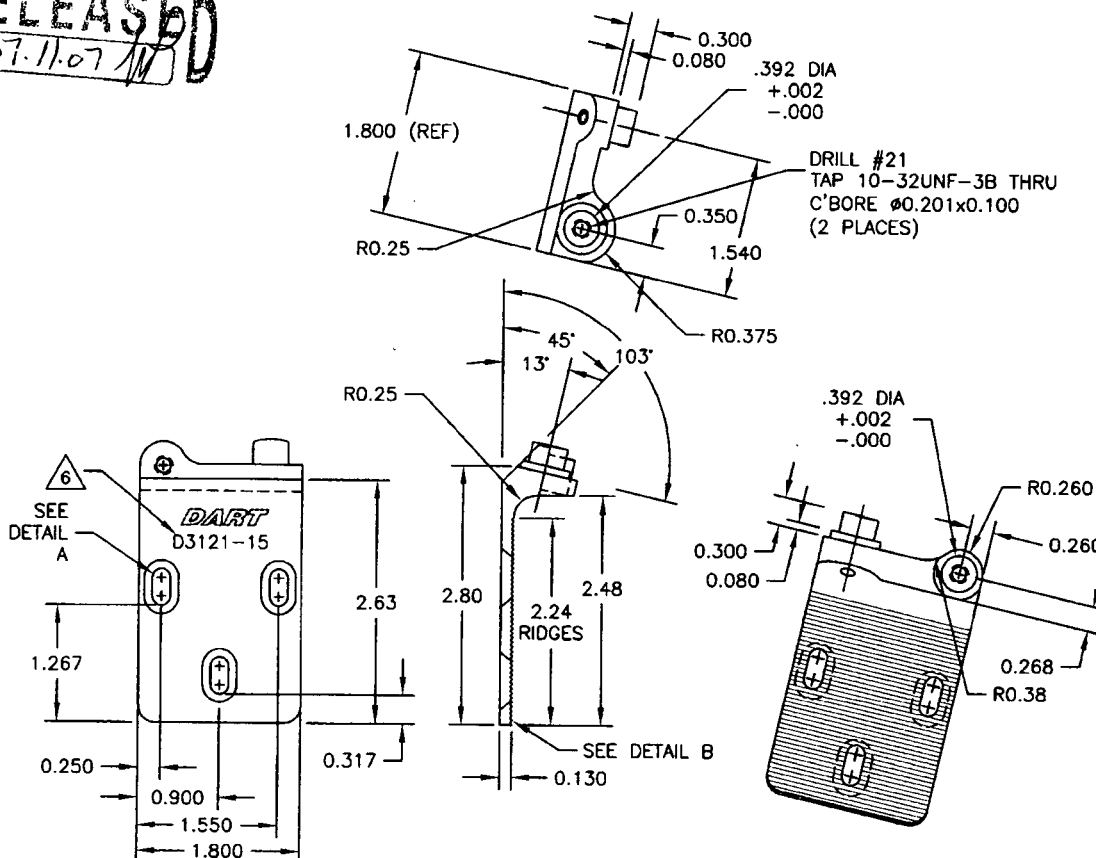
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 6 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



D3121-15 BRACKET (SHOWN)

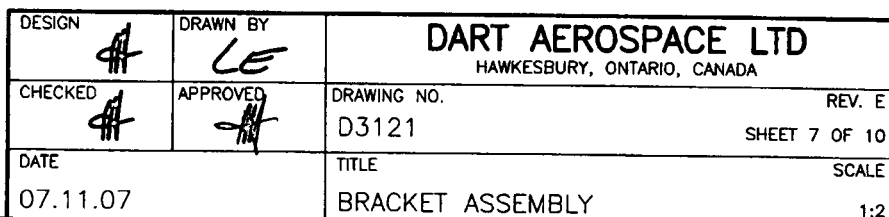
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

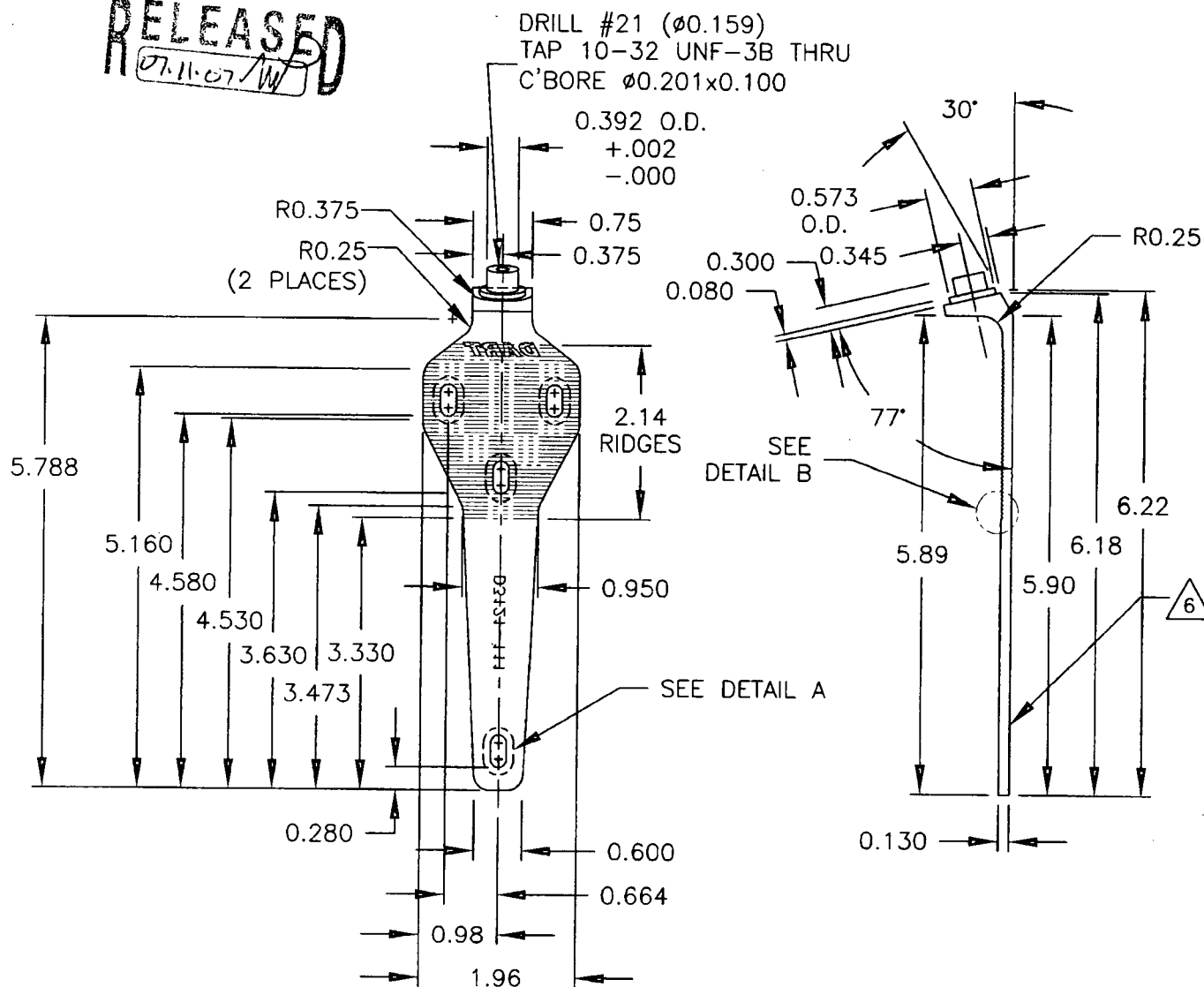
29366

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RELEASED
07.11.07



- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

89360

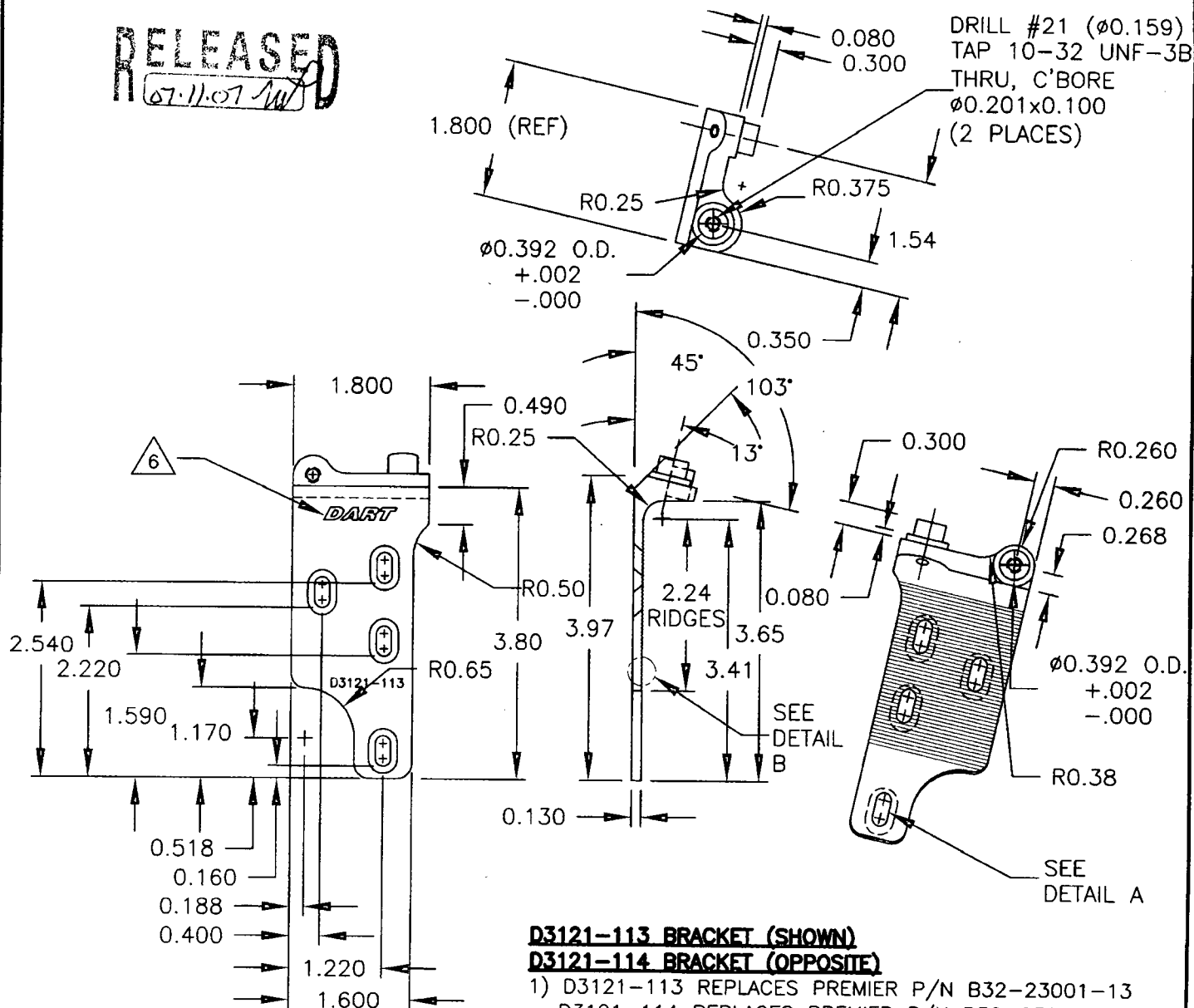
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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



D3121-113 BRACKET (SHOWN)

D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

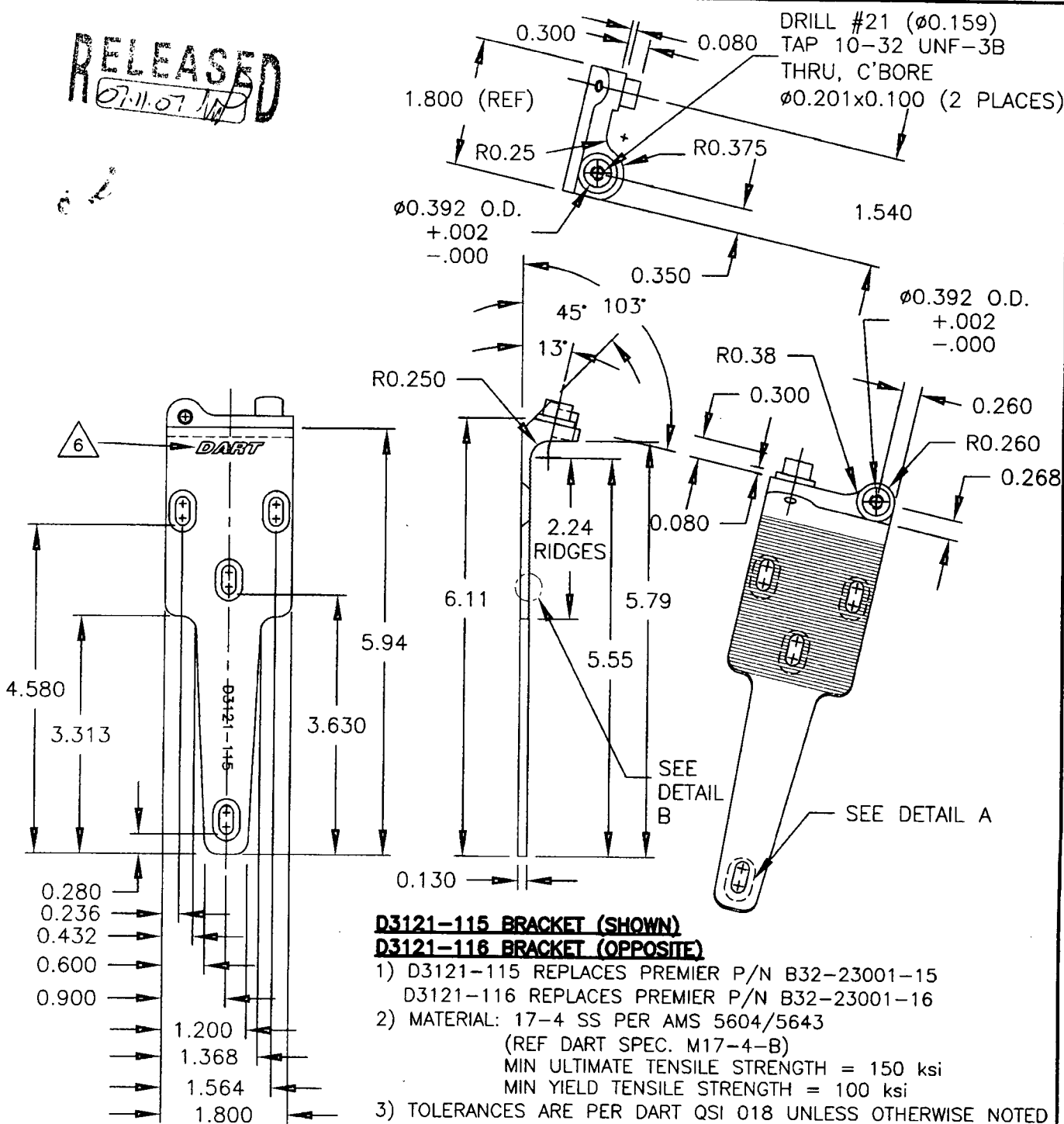
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07



D3121-115 BRACKET (SHOWN)

D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

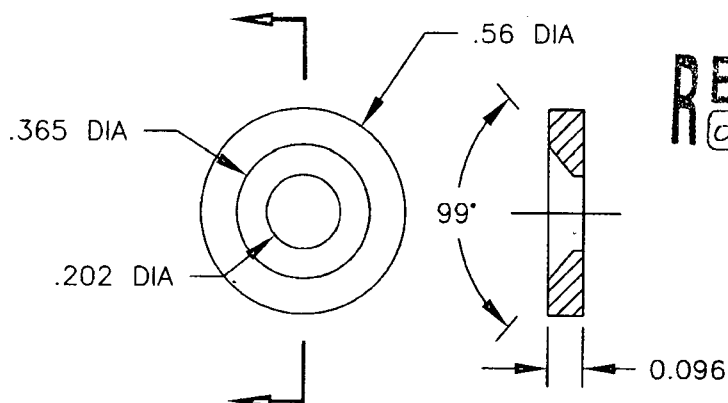
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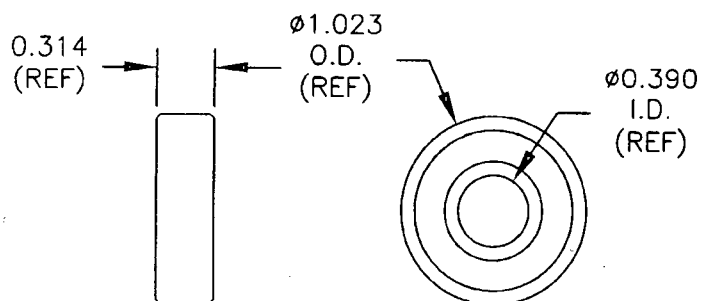


DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



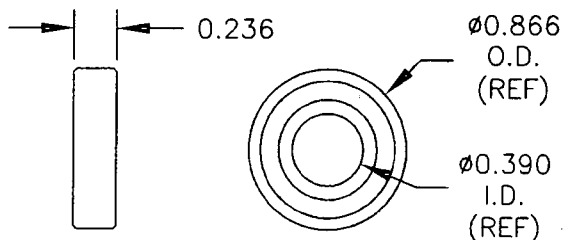
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

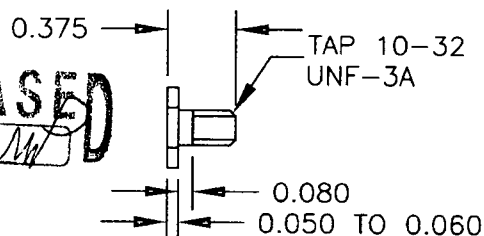
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

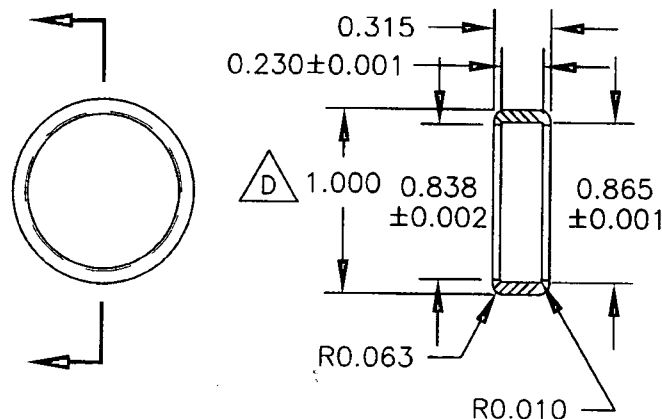
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.11.07



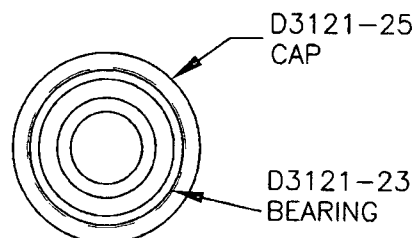
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

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